



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86553

July 5, 2012 10:17:49 AM

**\*86553\***

Page 2

Item ID: D2571 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, Fwd Out 205  
Start Date: 7/05/12 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 7/24/12 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 9:30 OVEN TEMPERATURE:  
FINISH TIME: 10:00

32001F

10:00

~~8/25/12 10:31~~

8X4

m-l  
12/07/31

m121841

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 86553****\*86553\***

Page 3

July 5, 2012 10:17:49 AM

Item ID: D2571

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Fwd Out 205

Start Date: 7/05/12

Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 7/24/12

Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

See f M n l o t k e

170

Identify as per dwg & Stock Location: ST441

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

8 12/07/31 JB

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/8 / 11 J

MCS 12/07/31

# Picklist Print

July 5, 2012 10:17:49 AM

Page 1

Work Order ID: 86553

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 7/05/12

Required Date: 7/24/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 Saddle Billet		Manufactured	No			100	Each	41.0000	1	8			

Location

Loc Qty

Loc Code

MAT041

30

85432

30

MAT042

11

79875

1

85432

10

8

FK 12/02/19.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 86553
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.566	.566	.566	.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.497	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.874	3.874	3.874		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.127	.127	.127	.127		
R	0.240	0.260		.254	.254	.254	.254		
S	0.115	0.135		.132	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.244	.244	.244	.244		
W	0.115	0.135		.125	.124	.124	.124		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.629	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.258	.258	.258	.258		
AE	1.375	1.395		1.3872	1.3894	1.389	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.254	.254	.254	.254		
AI	2.000	2.020		2.002	2.0035	2.003	2.0035		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject							DAS		

Measured by: <i>JS</i>	Audited by: <i>14</i>
Date: 12/07/24	Date: 12/07/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	86553
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5x	6x	7x	8x		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.566	.566	.566	.566		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
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AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.258	.258	.258	.258		
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AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.254	.254	.254	.254		
AI	2.000	2.020		2.004	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DA
Date:	12.7.27

Audited by:	14
Date:	12/02/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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**NOTE:** Date & initial all entries

RELEASED

05.12.13

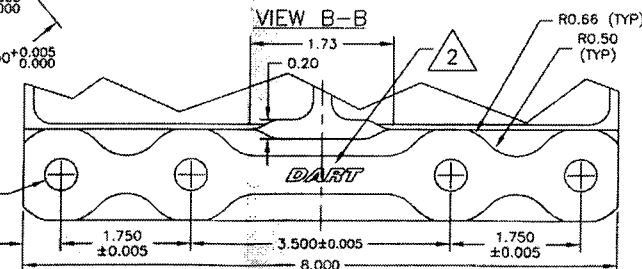
# NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES: TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE
		2:3

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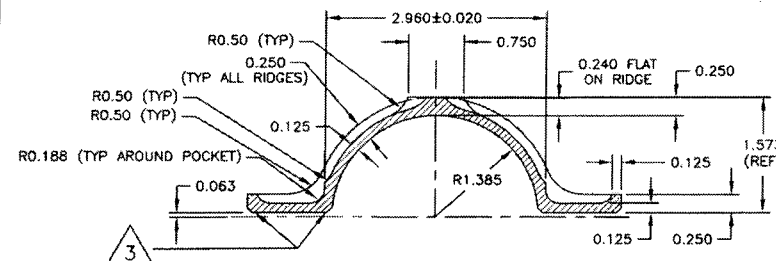
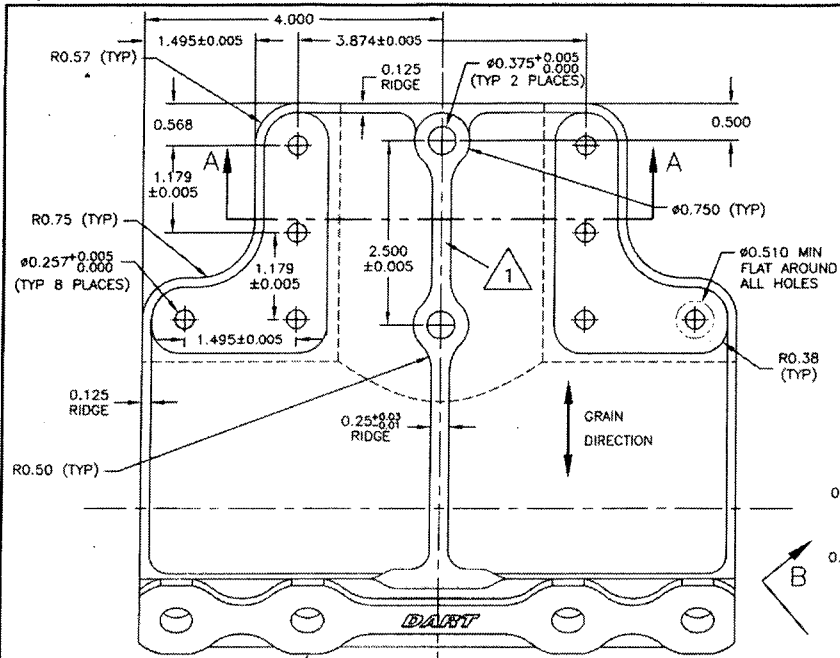
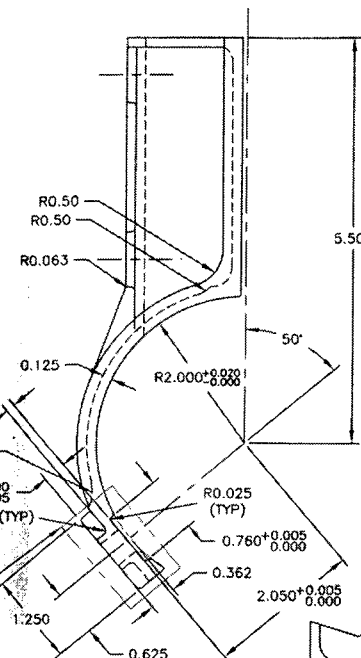
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DETAIL C  
 SCALE 4:3

R0.025 (REF, TYP)

DETAIL C

B



## SECTION A-A

0212107105  
 W10' 86553

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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